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⑤ Applicant: ALLIED COLLOIDS LIMITED  
P.O. Box 38 Low Moor  
Bradford West Yorkshire, BD12 0JZ(GB)

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⑦ Inventor: Allen, Anthony  
35 The Poplars Guiseley  
Leeds West Yorkshire, LS20 9PF(GB)

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⑨ Representative: Lawrence, Peter Robin  
Broughton et al  
GILL JENNINGS & EVERY 53-64 Chancery  
Lane  
London WC2A 1HN(GB)

⑩ Ore pelletisation.

⑪ Finely divided mineral ore is pelletised using a soluble synthetic polymer. Preferably the polymer is in the form of beads made by reverse phase polymerisation and all having a size of below 300μm. When the ore gives a pH in water of below 8 the soluble polymer is preferably cationic.

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EP 0 288 150 A1

**Ore Pelletisation**

Iron ore needs to be in the form of agglomerates of substantial size when it is charged into a blast furnace. If the available ore is in the form of particles that are too small for direct feed to the blast furnace it is necessary to convert them to a sinter or to pellets. With the increasing use of lower grade ores it has become necessary to grind the ore more finely and, for these fine particles, pelletisation is the only satisfactory method of production of feedstock for the furnaces.

The pellets are made by adding binder to the fine particulate ore and stirring in the presence of a small amount of water (generally moisture in the ore) to form a moist mixture, and then pelletising the mixture, e.g., in a balling drum or disc pelletiser. The green pellets are then fired in a kiln through a temperature range that extends from an inlet temperature typically in the range 200-400°C up to a final temperature of e.g., 1200°C.

Important properties of the pellets are the initial or wet strength, the dry strength (after drying the green pellets in an oven at 105°C) and the tendency of the pellets to spall (or burst) upon exposure to firing temperatures. The tendency for spalling can be defined by determining the minimum temperature at which spalling occurs or by observing the percentage of fines formed during a particular firing cycle. The moisture content of the mixture and the porosity of the pellets must be chosen carefully. A high "drop number" for the green pellets is desirable. For cost reasons the amount of binder should be as low as possible and, to ensure uniform properties, its flow properties must be such that it can easily be added uniformly in these low quantities.

Although many binders have been proposed in the literature, (e.g., bentonite and other clays, ferrous sulphate, lignin sulphate, asphalt, starches, calcium and sodium compounds, and certain polymers) in practice bentonite is the binder that is generally used.

In GB 1,324,838 work was described that was conducted in or before 1970, more than 15 years ago. This used, as binder, a water soluble linear organic polymer having a molecular weight of 1 million to 20 million. Suitable polymers were modified natural polymers such as starch and sodium carboxymethyl cellulose and various non-ionic, anionic or cationic synthetic polymers. The process involved forming a solution of the polymer and spraying the solution on to the particulate iron ore. The patent noted that the sprayed solution was viscous and that this could be a problem, but that the viscosity could be reduced by including sodium chloride, sodium sulphate or potassium chloride in the water used for making the solution.

Although direct comparisons of the polymers in GB 1,324,838 is difficult it appears from the patent that various non-ionic, anionic and cationic polymers can be used to give improved green strength and/or spalling properties compared to bentonite, at very much lower dosages than bentonite. For instance a straight chain polyethylene oxide was reported as giving improved strength and spalling values and a cationic copolymer and a polymer formed from about 8% sodium methacrylate and 92% acrylamide were reported as giving improved strength values.

A disadvantage of the process in GB 1,324,838 is that it is necessary to introduce substantial amounts of water with the polymer and so the initial iron ore must be very dry (involving the use of drying energy) or the final pellets will be very wet (increasing the risk of spalling).

In Aus.I.M.M. Newcastle Pellets and Granules Symposium October 1974 pages 151 to 156 R.L.Smythe describes what appears to be the same work as is discussed in this patent. It describes the problems that had been incurred with converting dry powder polymer into the polymer solution that could be sprayed on to iron ore. The article proposed the use of polymer supplied as a 35% solution (necessarily therefore involving bulk handling problems) and the use of polymer supplied as a liquid suspension, that presumably was converted to an aqueous solution before use. The article warned about handling problems of the resultant pellets and the risk of blockage of chutes and referred to the study of alternative polymers, namely "natural polymers and derivatives of petroleum products".

Despite all this work in the early 1970's an authoritative review of iron ore pelletisation by G.K.Jones in Industrial Minerals March 1979 pages 61 to 73 mentions, as binders, only Portland cement, lime and bentonite, and emphasises the large amount of bentonite that is used and credits that it will continue to be used despite the shortages of bentonite.

Despite the acceptance by Jones, and the whole industry, that bentonite would continue to be the most widely used binder it has, for very many years, been recognised to incur various problems. Thus some grades of bentonite give satisfactory pellet properties but others are less satisfactory. A problem with all grades of bentonite is that the bentonite is not combustible and so contributes to the gangue in the furnace, and this gangue tends to be corrosive to the lining of the furnace. Another problem with bentonite is that the optimum grades are becoming less available. Bentonite must be present in the pellets in quite large

amounts, thus reducing the iron content of the pellet significantly and increasing the amount of gangue. Lime and some inorganic salts have been proposed as alternatives to bentonite, but again they cause the formation of unwanted gangue and can be less satisfactory than bentonite. The added gangue constituents require increased energy consumption in the furnace.

- 5 A problem with bentonite and other binders is that the spalling temperature is low. Typically the inlet temperature of the kiln has to be in the range 200 to 400°C to prevent spalling. Higher inlet temperatures would be economically desirable if spalling could still be avoided.

In Mining Engineering October 1984 pages 1437 to 1441 de Souza et al reported that organic binders would have the inherent advantage, over inorganic binders, of being eliminated during firing. Results were reported on the use of polymers based on cellulose, in particular the material sold under the trade name Peridur and which is believed to be carboxymethyl cellulose. The article reported adding Peridur powder to an aqueous pulp of iron ore before filtration and also reported adding the powder manually to the ore flow. The article noted the need for water soluble polymers to be hydrated and dissolved during mixing and pelletising. Spalling at 250°C was reported, but this is unsatisfactorily low.

- 10 15 A difficulty with powdered cellulosic binders such as carboxymethyl cellulose is that the irregular particle shape and size distribution is such that the powder does not flow freely. Instead the dry particles tend to clump together rather than flow over one another. As a result it is difficult to achieve uniform supply of the low dosages that are required. Another problem is that the amount of cellulosic binder that has to be used for adequate strength tends to be too high to be cost effective. Another problem with some cellulosic polymers is that they can reduce surface tension, and this appears to be undesirable in pellet formation.

20 In practice the use of cellulosic binders has not been widely adopted, presumably because of these or other problems. At present therefore there is very little use of organic binders and bentonite is still very widely used, despite the long-recognised disadvantages and decreasing availability of suitable grades of bentonite and despite the long-established possibility of using organic binder.

- 25 25 In EP 0203855A2 (not published until after the priority date of this application) it is proposed to use a water soluble high molecular weight polymer in the form of a dry powder or, preferably, a water-in-oil emulsion that preferably contains both water-in-oil and oil-in-water surfactants. Non-ionic, anionic and cationic polymers are proposed. The use of the polymer in combination, with an inorganic salt, to increase strength, is also proposed.

30 30 Spalling properties are not discussed in a manner that allows judgement as to whether these polymers could give improved spalling properties compared to the spalling properties of bentonite.

The only dry powders that are specifically proposed in EP 0203855A2 are Rhone Poulen AD10 which is said to be a non-ionic polyacrylamide having intrinsic viscosity (IV) 15.4dl/g and which we believe to be a coarse crushed gel product, and Percol 725 and Percol 726, both of which are made by the assignees of the present application. Percol 725 is a crushed gel copolymer having IV about 18 of 80% acrylamide and 20% by weight sodium acrylate and Percol 726 is a bead copolymer of about 65% acrylamide and 35% by weight sodium acrylate and has IV about 17. In particular the bead form of Percol 726 is made by reverse phase polymerisation and a significant amount of the particles have a dry size above 450μm and up to about 800μm, and the crushed gel of Percol 725 also has a particle size of up to about 800μm.

- 35 40 When considering possible binders that might be used there are several critical factors that have to be recognised. The iron ore always has a very small particle size, and therefore a huge surface area. The binder must be introduced with the absolute minimum of water in order that the pellets can conveniently have a total moisture content of not more than about 15%. The duration and energy of mixing the binder with the iron ore particles must be as short as possible in order to maximise production and minimise capital costs. The amount of binder must be as low as possible in order to minimise cost and to avoid the risk of excess binder accentuating the stickiness problems noted in the article by R.L.Smythe.

Bentonite has a very small particle size (typically below 10μm) and adequate admixture of these very small particles with the particulate iron ore is achieved because the bentonite is used in a relatively large amount (typically 1%). However it would be expected that the use of a binder that is substantially coarser and/or present in a substantially smaller amount would tend to give less satisfactory results, due to non-uniform mixing of the binder with the relatively large volume of very fine particulate iron ore.

- 45 50 The use of cellulosic binders or the powder or emulsion binders proposed in EP 0203855A2 is inconvenient from the point of view of application methods that give reasonable results. Also the results are, at best, generally no better than those obtainable with bentonite, and they are often worse. It has been our object to improve application methods and/or obtain better results.

55 In the methods of the invention mineral ore pellets are made by adding binder comprising organic polymer to particulate mineral ore having substantially all particles below 250μm and stirring in the presence of about 5 to about 15% by weight water (based on total mixture) to form a substantially

homogeneous moist mixture and pelletising the moist mixture.

In EP225171 (not published at the priority date of this application) there is claimed a process in which iron ore pellets are made by adding binder comprising organic polymer to particulate iron ore having substantially all particles below 250 $\mu\text{m}$  and stirring in the presence of 5 to 15% by weight (based on total mix) to form a substantially homogeneous moist mixture and pelletising the moist mixture, and the process is characterised in that the binder comprises up to 0.2% by weight, based on total mix, of a water soluble synthetic polymer that has intrinsic viscosity 3 to 16d/l/g and that is an anionic polymer of one or more water soluble ethylenically unsaturated monomers comprising an anionic monomer and that is added to the iron ore as a dry, free flowing, powder having substantially all particles above 20 $\mu\text{m}$  and below 300 $\mu\text{m}$ .

Although that process is very successful for pelletising conventional iron ores it has been found that less satisfactory results are obtained with some unusual ores, for instance one particular of haematite iron ore in Canada. It has been ascertained that this particular ore as supplied is acidic, in that has a much lower pH than normal pelletising ores.

In the invention pellets are made from mineral ore by adding binder comprising organic polymer to acidic particulate mineral ore having substantially all particles below 250 $\mu\text{m}$  and stirring in the presence of 5 to 15% by weight water (based on total mix) to form a substantially homogeneous moist mixture and pelletising the moist mixture, and in this process the binder comprises about 0.02% to about 0.5% by weight, based on total mix, of water soluble polymer that is cationic.

When a small amount, e.g., 2 to 10% by weight, of particulate ore is slurried with water the pH of the resultant water may depend upon the amount of ore that is used but at higher amounts of ore, typically 30 to 40% solids, the pH becomes substantially independent of the amount of ore. It is this pH, that is substantially independent of ore concentration, which is intended herein when reference is made to the ore giving a specified pH. Normal ores give a pH of above 8.1, typically 8.2 to 8.4 or higher. The invention is of particular value when the ore is acidic and thus gives a pH in this test of below 7, and often below 6.

By the invention it is possible to obtain very good pelletising results even at very low pH values. This is in marked contrast to existing systems, and especially systems using bentonite, where reasonable results are sometimes obtainable at pH values 7 to 8 but the results at lower pH values, for instance 6.5 to 4 or even down to 3, are totally inadequate in most instances. Thus the invention permits, for the first time, satisfactory pelletising of acidic, and often highly acidic, ores.

The mineral can be any acidic ore, e.g., a zinc ore, but is preferably an iron ore, normally a haematite, magnetite or tachonite. The ore may be naturally acidic or may have been rendered acidic by some treatment prior to blending with the binder. For instance the ore may have been washed with acid to remove acid soluble components, typically to produce a pH of from 5 to 6 if manganese is being washed out of the ore.

The ore may have acquired an acidic pH during other processing treatments. For instance the ore may be dried under conditions that result in the dry ore giving the specified relatively low pH in water. This may be because, for instance, the drying is conducted using hot gases that contain sulphur or other impurities that cause acidification of the ore during drying or may be due to chemical changes in the surface properties of the ore that are caused by dehydration.

As a result of the invention it is possible, for the first time, to use for pelletising ores that hitherto would have been rejected, either because of their acidity or because of their low grade. The reason why it is now possible to use low grade ores for pelletising is because a preferred process of the invention comprises forming acidic particulate ore from the mineral ore (that can be of low grade) by a process comprising washing or leaching the mineral ore in acid, and thereafter using the resultant, enriched, acidic particulate ore for pelletising. It has not previously been practicable to use acid washed or acid leached ores for pelletising. The ore that is acid washed or leached is normally an iron ore.

Numerous methods of purifying or enriching mineral ores by acid treatment are well known, and can be used in the invention.

The soluble cationic polymer is formed by the polymerisation of cationic ethylenically unsaturated monomer, optionally with other ethylenically unsaturated monomers. The monomer or monomer blend will normally be water soluble. One suitable class of cationic monomers are the dialkylaminoalkyl (meth) acrylates, especially dimethylaminocetyl (meth) acrylate (DMAEA or DMAEMA). Another suitable class are the dialkylaminoalkyl (meth) acrylamides. A suitable material is dimethylaminocrooyl (meth) acrylamide. All such monomers are generally present in the form of acid addition or quaternary ammonium salts. For instance a suitable monomer is methacrylamido crooyl trimethyl ammonium chloride (MAPTAC). Other suitable cationic monomers include diallyl dialkyl quaternary monomers, especially diallyl dimethyl ammonium chloride (DADMAC). Preferred cationic polymers are polymers having recurring quaternary ammonium groups. Blends of cationic polymers, e.g., a blend of synthetic cationic with natural or modified natural

cationic polymer) can be used.

The polymers can be copolymerised with non-ionic monomers, generally (meth) acrylamide (ACM). Other suitable cationic polymers are polyethylene imines and epichlorhydrin polyamine reaction products made in bead form. We find that homopolymers and other polymers having a very high cationic content can be of relatively low molecular weight, for instance having intrinsic viscosity below 5 dl/g, often in the range 0.4 to 2 dl/g. When such polymers are formed from ethylenically unsaturated monomers at least 70 weight percent, and preferably at least 90 weight percent, of the monomers should be cationic, and preferably the polymer is substantially a homopolymer.

Other preferred polymers have medium to high molecular weight and medium cationic content. For instance the IV may be from about 3 to about 20 dl/g or higher, generally 3 to 12 dl/g, preferably from 5 to 9 dl/g. Such polymers are best made by copolymerisation of about 20 to about 75, preferably about 25 to about 60, weight percent cationic monomer with a non-ionic monomer such as acrylamide. Best results are generally obtained with about 35 to about 55 weight percent cationic monomer, with the balance non-ionic.

Although best results are achieved most easily when the cationic polymer is added in the form of water soluble beads all below 300 microns, as discussed below, in some instances the cationic polymer can be added in other forms. Thus it can be added in the form of particles that are within the size ranges discussed above for beads but which have been made by comminution of gel in air or, preferably, in an organic liquid for instance as described in EP 169674. It may be necessary to sieve the particles to give the desired particle range and to exclude oversize particles.

Instead of being a synthetic polymer, it can be a naturally occurring polymer (or a modified natural polymer) such as Chitosan or cationic starch, but this usually less satisfactory than the use of synthetic polymers.

When the ore is wholly dry, or is drier than is required in the moist pelletising mixture, it is necessary to add water to the ore in order to form the moist mixture and it is then possible to incorporate the polymer as a solution in this water. For this purpose the polymer can initially be provided in any suitable physical form. When the polymer is being added as a solution, the aqueous polymer solution may be sprayed on to the ore prior to pelletising. The solution can be made from polymer in the form of a concentrated solution, a polymer-in-oil dispersion or powder. Alternatively the polymer-in-oil dispersion of the polymer can be added direct to the ore. The polymer particles in any such dispersion can be dry or can be swollen gel particles.

Preferably however the polymer is added in the form of dry, free flowing powder having substantially all particles below about 300 $\mu$ m, usually in the range about 20 to about 300 $\mu$ m. The particles can be comminuted gel, especially if the comminuted gel particles had been formed or treated in known manner so as to promote their flow, but preferably the particles are beads, for instance as made by reverse phase bead polymerisation.

Reverse phase bead polymerisation is a well known process. Thus an aqueous solution of the chosen monomer or monomer blend is dispersed in water immiscible liquid, generally in the absence of an emulsifying agent but often in the presence of an amphiphatic polymeric stabiliser, the polymerisation is induced in conventional manner to provide a suspension of gel particles in the non-aqueous liquid, the suspension is then dried by azeotropic distillation and the particles are separated from the non-aqueous liquid in conventional manner. The desired particle size range is controlled in known manner, for instance by the choice of stabiliser, emulsifying agent (if present) and, especially, the degree of agitation during the formation of the initial suspension of aqueous monomer particles in the water immiscible liquid. The beads are substantially spherical.

Some reverse phase polymerisation methods involve the use of relatively large amounts of emulsifiers or other materials that depress surface tension. It is particularly desirable in the invention to make the polymer particles in the substantial absence of any such material. In particular, it is desirable that the entire binder (and also the polymer component of the binder) should have substantially no depressant effect on surface tension. Thus if binder is dissolved with water at 20°C at 0.075% by weight concentration the surface tension of the solution should be above 65, and preferably above 70 dynes/cm. Thus it is preferred to avoid the use of amounts of surfactant that would depress surface tension significantly and reliance should be placed instead on agitation or stabiliser, in known manner, to control bead size.

Although it might have been expected to be desirable to use swellable but insoluble particles (in an attempt at matching the properties of bentonite) in fact the use of such polymer as the only polymer is unsatisfactory and soluble polymer must be used.

The failure of the cross-linked polymers, and the article in Mining Engineering October 1984 page 1438, might have indicated that it is necessary for the polymer to go into solution and/or to form a viscous mass during mixing, but results can be improved (or the required polymer dose reduced) by the presence in the water of certain simple compounds. Many of these are monomeric, usually inorganic, electrolyte that can be

shown experimentally to reduce the rate of solution and the viscosity when the polymer is dissolved into bulk water. However it appears that some mechanism other than depression of solubility or viscosity is involved. In practice the water is generally moisture that is present in the ore, remaining from a previous filtration stage, and this water is itself normally a solution of one or more inorganic electrolytes.

5 Although this contamination appears satisfactory results are improved further, and often synergistically, if the powdered binder that is added to the ore includes additional monomeric compound that is usually an inorganic or organic electrolyte but can be a non-electrolyte.

The compound is normally water soluble and inorganic and so is preferably a water soluble salt of an acid. However salts of strong acids (e.g., sodium chloride, sulphate or nitrate) are less satisfactory than salts 10 of weak organic acids or carbonic acid. The strong acid salts may generate corrosive acids during smelting or firing. Accordingly preferred compounds that are incorporated as part of the binder are organic molecules such as urea, inorganic water soluble salts of carboxylic, dicarboxylic and tricarboxylic acids such as sodium acetate, sodium citrate, sodium oxalate, sodium tartrate, sodium benzoate and sodium stearate, other sodium salts of weak acids such as sodium bicarbonate and sodium carbonate, other miscellaneous sodium salts such as sodium silicate or phosphate, the corresponding ammonium, potassium, calcium or magnesium salts of the preceding salts and calcium oxide. Sodium carbonate, bicarbonate or silicate are generally preferred as they give the best anti-spalling and dry strength results.

An important advantage of the use of beads made by reverse phase bead polymerisation is that they 20 can readily be added in very uniform and very small amounts to the ore that is to be pelleted, because of the substantially spherical shape of the beads. If the binder is to be a blend of the polymer with other material such as any of the compounds discussed above then this other material should also be added in a form that is easily flowable on to the ore. Preferably the compound is incorporated in the beads. For instance a salt of a weak acid can be present in the aqueous monomer during polymerisation. Alternatively the compound can be added separately to the ore or it can be preblended with the polymer beads, but in either instance the compound itself is preferably put into a free flowable, generally bead, form, by known techniques.

The optimum amount of added salt or other compound can be found by experimentation. For many purposes it is in the range 0 to about 60% by weight based on the binder (below 0.1% and usually below 0.02% based on ore). In some instances amounts of from about 10 to about 30% based on soluble polymer 30 are the most cost effective but usually greater amounts, for instance 30 to about 100% or even 150%, preferably 50 to 90%, based on soluble polymer are preferred.

The soluble polymer (in bead or other form), optionally with the added salt or other compound, can be used in combination with other binders. In particular, despite the fact that cross linked polymers have proved, by themselves, to be unsatisfactory we find valuable results are achieved if a cross linked, 35 swellable, particulate organic polymer is included with the soluble polymer. The cross linked polymer must have a small particle size, below 100 $\mu\text{m}$  and often below 50 $\mu\text{m}$ . The size can be as small as is commercially available, e.g., down to 10 $\mu\text{m}$  or 1 $\mu\text{m}$ . The particles are normally introduced as dry powder and preferably this powder is in the form of bead fines separated during the production of coarser particulate swellable polymer as produced by bead polymerisation. The inclusion of the cross linked 40 polymer particles can give surprisingly improved dry strength and drop number values and so a blend of soluble particles and cross linked particles can give an excellent combination of dry strength, wet strength and spalling properties. Also the pellets tend to have improved surface appearance, such as smoothness.

The cross linked polymer may be non-ionic (e.g., polyacrylamide), but when the soluble polymer is 45 ionic it is preferably of the same ionic type as the soluble polymer and so may be formed from the same monomers as are discussed below for the preparation of the soluble polymer. Preferably 20 to 100% by weight, most preferably 60 to 100% by weight, are ionic. The use of homopolymer, e.g., cross linked sodium polyacrylate, is very satisfactory. Cross linking may be by any of the conventional cross linking agents used in the production of swellable or absorbent polymers. Thus it may be by an ionic cross linking agent but is preferably covalent, e.g., methylene bis acrylamide or other polyethylenically unsaturated 50 monomer. The amount of cross linking agent is generally in the range 20 to 1,000 ppm, preferably 50 to 500 ppm, and must be such that the particles are insoluble but highly swellable in water, e.g., having a gel capacity in water above 50, and preferably above 200, grams per gram.

The amount of cross linked polymer particles may be relatively low, e.g., 10 to 30% based on soluble 55 polymer, but generally greater amounts, e.g., up to 300% or even 600% based on soluble polymer are preferred. Amounts of 0 to 80% often 20 to 50%, based on total binder are suitable. Particularly preferred binders consist essentially of 1 part by weight soluble polymer, 0.3 to 1.5 parts by weight sodium carbonate or other added salt or simple compound, and 0.3 to 5 parts by weight cross linked anionic homopolymer or copolymer, with proportions of about 1:1:1 often being convenient.

Substantially all the particles of the soluble polymer (and of other binder particles) must be below about 300 $\mu\text{m}$  for good results, presumably since otherwise the particle size is too large to establish adequate contact with the very large number of very small iron ore particles. Preferably substantially all the polymer particles are below about 200 and preferably below about 150 microns. Although it might be expected to be necessary to have exceedingly small polymer particle size, similar to bentonite, this is unnecessary and it is satisfactory for most or all of the particles to be above 20 microns. Best results are often achieved when substantially all the polymer particles are in the range 20 to 100 microns but a satisfactory fraction is 100% below about 200 $\mu\text{m}$  and at least 50% below about 100 $\mu\text{m}$ .

- 5 Good results are achieved at very low soluble polymer additions. The amount, therefore, is usually below about 0.2% and generally it is below about 0.1% (by weight based on the total mix). It is often preferred for the amount to be below 0.05% by weight, but amounts below 0.01% are usually inadequate except when the soluble polymer is used with significant (e.g., at least 20% by weight) other binder components, the amount of soluble polymer may then sometimes be reduced, e.g., to 0.005%.

10 The particle size of the ore is generally less than 250 microns, usually 90% or 80% by weight of the particles being less than 50 microns. The ore is preferably an iron ore such as magnetite, haematite or taconite, but can be any other mineral ore that needs to be put into the form of pellets, for instance a zinc ore. Satisfactory results can be obtained even if the ore is contaminated with clay.

15 Before adding binder in the form of dry polymer, the ore usually already has the desired final moisture content of 5 to 15%, preferably 8 to 10%, by weight based on the weight of iron ore. This moisture content is the moisture as measured by heating up to 105°C. However if the ore is too dry then water may be added to it, e.g., before or after the addition of polymer binder (or the binder may be predissolved).

20 The binder can be blended with the ore in the same manner as bentonite is blended, preferably by scattering the polymer particles on to the ore as it is carried towards a mixer, for instance a paddle mixer provided with stators. It may be mixed for the same duration as when bentonite is used, for instance 2 to 25 20, generally about 10, minutes.

25 The damp blend of ore and polymer is converted to pellets in conventional manner, for instance by balling in conventional manner. This may be effected using a rotating tilting disc but generally is conducted in a balling drum. The size of the pellets is generally from 5 to 16 mm, preferably 8 to 12 mm.

30 Before the resultant green pellets can be utilised for the production of metal they need to be fired, generally at a temperature up to above 1000°C, for instance up to 1200°C. For this purpose they can be introduced into a kiln or other firing apparatus and fired in conventional manner, it is desirable to be able to introduce them into this furnace at the highest possible inlet temperature with the minimum risk of spalling. The inlet temperature at which spalling becomes significant can be referred to as the spalling temperature and a particular advantage of the invention is that it is possible to make pellets having a spalling temperature higher than can conveniently be obtained by the use of bentonite and other known binders.

35 Good results can be achieved while using easy application techniques and low amounts of polymer. It is easy to make pellets which have satisfactorily high wet strength and dry strength (measured after drying in an oven) and a satisfactorily high drop number when wet (indicating the number of drops before they shatter). In particular it is possible to obtain excellent spalling properties, often much better than are obtainable with bentonite.

40 In a second aspect of the invention, a modification is provided in the process described in EP225171 for the treatment of conventional ores, especially iron ores, e.g., those giving a pH above 8. Although optimum results are more easily obtained, with or without added sodium carbonate or other inorganic salt, when using a soluble anionic polymer having intrinsic viscosity of about 3 to about 16, as in that U.S. patent, it has now been found that it is possible to obtain useful pelletising with other anionic polymers under particular circumstances.

45 In particular, the invention also includes a process in which organic polymer is added to conventional particulate iron or other ore having substantially all particles below 250 $\mu\text{m}$  and stirring in the presence of 5 to 15% by weight water (based on total mix) to form a substantially homogeneous moist mixture and pelletising the moist mixture, the process being characterised in that the binder comprises up to 0.2% by weight, based on total mix, of water soluble synthetic polymer that has intrinsic viscosity above about 17 dL and that is an anionic polymer of one or more water soluble ethylenically unsaturated monomers comprising an anionic monomer and the binder also comprises about 10 to about 150%, based on total binder, of added salt or other monomeric compound as discussed above. Although the high IV anionic monomers cannot be used alone, adequate results are obtainable when blended with such salt or other monomeric compound, for instance in proportions by weight 2:1 to 1:2. The very high molecular weight polymer is introduced in the form of fine powder which can be beads or crushed gel. The particle sizes and other characteristics of the anionic polymer, suitable inorganic materials and cross linked polymeric and other

additives may all be as described above for the cationic binders.

In a third aspect of the invention, that is applicable to all types of ores, the binder comprises about 0.005% to 0.5% by weight, based on total mix, of a water soluble synthetic polymer that is added to the ore as dry, free flowing, beads that are substantially all above 20 $\mu\text{m}$  and below 300 $\mu\text{m}$  and that are made by reverse phase bead polymerisation from water soluble ethylenically unsaturated monomer or monomer blend.

The polymer of the beads preferably is not anionic polymer of intrinsic viscosity 3 to 16. Thus it may be anionic below 3 and preferably below 2, anionic above 16 and preferably above 17, nonionic or cationic. The bead polymer may be mixed with other polymer particles and/or add salts, for instance as described above.

In examples 1 and 2 below the binders were each scattered onto acidic moist particulate haematite iron ore at an appropriate dosage. The moisture content was 8.3%. The blend was then converted to pellets in a balling drum, the pellets having a size typically of about 5-16mm.

The following synthetic cationic polymeric binders were used. They were made by reverse phase polymerisation to a bead size below 200 $\mu\text{m}$  and the beads were dried and separated. Polymer A copolymer of 40% methyl chloride quaternised dimethylaminoethyl acrylate (MeCl.q DMAEA) 60% acrylamide (ACM)

IV = 7-8 dl $\text{g}^{-1}$

Polymer B : copolymer of 50% MAPTAC with 50% ACM  
IV = 6-9 dl $\text{g}^{-1}$

Polymer C : 100% PolyMAPTAC IV = 1.3 dl $\text{g}^{-1}$

Polymer D : copolymer of 60%-MeCl.q DMAEA with 40% ACM

IV = 6-7 dl $\text{g}^{-1}$

Polymer E : copolymer of 80% MeCl.q DMAEA with 20% ACM

IV ~ 8-9 dl $\text{g}^{-1}$

Polymer F : 100% Poly-diallyldimethyl ammonium chloride solid grade

IV = 0.7 dl $\text{g}^{-1}$

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### Example 1

An ore from the Wabush mine was dried, giving a pH of 6.2, and was blended while moist with the binder. The wet strength, dry strength, drop number and softening temperatures were recorded, as shown in Tables 1 and 2 below.

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Table 1

	Dose % w/w	Wet Strength/kg	Dry Strength/kg	Drop Number	% Moisture
Blank	-	0.56	0.59	7.9	8.0
Bentonite	0.7	1.17	8.20	18.5	10.0
Peridur	0.04	0.56	0.14	9.2	8.7
Polymer A	0.04	0.92	1.24	22.7	8.8
Polymer B	0.04	0.72	1.82	19.2	9.4
Polymer C	0.1	0.86	3.31	8.2	8.2

Table 2

		% Spalled		
		700°C	850°C	1000°C
Blank		0	70	100
Bentonite		40	50	100
Peridur		-	100	-
Polymer A		-	0	80
Polymer B		-	10	100
Polymer C		0	0	70

Example 2

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An acid leached iron ore having pH about 5 was used and the following results were obtained.

Table 3

	Dose % w/w	Wet Strength/kg	Dry Strength/kg	Drop Number	% Moisture
Polymer A	0.04	0.49	1.61	8.2	8.9
B	0.04	0.50	2.15	16.9	9.1
D	0.04	0.58	2.11	6.8	8.0
E	0.04	0.51	1.94	5.4	7.8
F	0.1	0.48	3.50	4.2	7.9

Spalling was tested for all cinders at 850°C and for cinders B, E and F at 1000°C. No spalling occurred.

Example 3

A gel polymer of 60% acrylamide 40% sodium acrylate having intrinsic viscosity 23.9dl/g was dried and comminuted in conventional manner to a particle size of around 100 $\mu$ m and is blended with an equal amount by weight of sodium carbonate particles. This binder was blended with iron ore giving a conventional alkaline pH, at a dosage of 0.04%. The spalling properties of the anionic synthetic polymer binder system at 1.000°C were excellent relative to the other systems and the other properties were satisfactory, although the moisture content was slightly higher than with the other systems.

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**Claims**

1. A process in which pellets are made from mineral ore by forming acidic particulate ore having substantially all particles below 250 $\mu$ m and that gives a pH in water of below 7 by a process comprising washing or leaching the mineral ore in acid and blending binder comprising organic polymer into the acidic particulate ore in the presence of 5 to 15% by weight water (based on total mix) to form a substantially homogeneous moist mixture and pelletising the moist mixture, and in which the binder comprises about 0.002% to about 0.5% by weight, based on total mix, of a water soluble polymer that is cationic.
2. A process according to claim 1 in which the polymer is synthetic and formed from ethylenically unsaturated monomers comprising a cationic monomer.
3. A process according to claim 1 or claim 2 in which the mineral ore is iron ore preferably one which gives a pH in water of below 6.
4. A process according to claim 3 in which the cationic polymer is selected from polymers that have intrinsic viscosity 0.4 to 5dl/g and that are formed from monomers of which at least 70% by weight are cationic, and polymers that have intrinsic viscosity of 3 to 20dl/g and that are formed by copolymerisation of 20 to 75 weight percent cationic monomer with 80 to 25 weight percent non-ionic monomer.
5. A process according to claim 3 in which the cationic polymer is substantially a homopolymer having intrinsic viscosity 0.4 to 2dl/g, the cationic monomer preferably being selected from diallyl dimethyl ammonium chloride and quaternised dialkylaminoalkyl (meth) acrylates and quaternised dialkylaminoalkyl (meth) acrylamides.
6. A process according to claim 3 in which the cationic polymer is a copolymer of 25 to 60 weight percent cationic monomer with 75 to 40 weight percent acrylamide and has an intrinsic viscosity in the range 3 to 12 dl/g.
7. A process according to claim 3 in which the cationic polymer is a copolymer of about 20 to about 60% acrylamide with about 80 to about 40% by weight of a quaternised monomer selected from dialkylaminoalkyl (meth) acrylates and dialkylaminoalkyl (meth) acrylamides and has intrinsic viscosity of from 3 to 12dl/g.
8. A process according to any of claims 3 to 7 in which the polymer is added to the ore as dry free flowing powder having substantially all particles above 20 $\mu$ m and below 300 $\mu$ m more preferably substantially all the particles being below 150 $\mu$ m preferably substantially 100% of the polymer particles being below 200 $\mu$ m and at least 50% being below 100 $\mu$ m and preferably in which the polymer is added in the form of beads made by reverse phase suspension polymerisation.
9. A process according to any preceding claim in which the binder gives a surface tension of above 70 dynes/cm at a concentration in water at 20°C of 0.075% by weight.
10. A process according to any preceding in which the amount of polymer is from 0.01 to 0.05% by weight.
11. A process according to any preceding claim in which at least 70% by weight of the acidic particulate ore has a particle size below 50 $\mu$ m.
12. A process in which pellets are made from mineral ore by adding binder comprising organic polymer to acidic particulate iron ore having substantially all particles below 250 $\mu$ m and stirring in the presence of 5 to 15% by weight water (based on total mix) to form a substantially homogeneous moist mixture and pelletising the moist mixture, and in which the binder comprises about 0.002% to about 0.5% by weight, based on total mix, of a water soluble polymer that is cationic and the ore gives a pH in water of below 7.
13. A process in which iron ore pellets are made by adding binder comprising organic polymer to particulate iron ore having substantially all particles below 250 $\mu$ m and stirring in the presence of 5 to 15% by weight water (based on total mix) to form a substantially homogeneous moist mixture and pelletising the moist mixture, characterised in that the binder comprises up to 0.2% by weight, based on total mix, of a

water soluble synthetic polymer that has intrinsic viscosity above 17dL/g and that is an anionic polymer of one or more water soluble ethylenically unsaturated monomers comprising anionic monomer, and the binder also comprises 10 to 150% by weight binder, of a compound selected from urea, sodium acetate, sodium citrate, sodium oxybate, sodium tartrate, sodium benzoate, sodium stearate, sodium bicarbonate, sodium carbonate, sodium silicate, sodium phosphate and the corresponding ammonium, potassium, calcium and magnesium salts of the preceding salts, and calcium oxide.

- 5 14. A process according to claim 13 in which the binder contains sodium carbonate, sodium bicarbonate or sodium silicate in an amount of 50 to 150% based on soluble polymer.
- 10 15. A process according to claim 13 or claim 15 in which the soluble polymer is added as a dry, free flowing, powder having substantially all particles above 20 $\mu$ m and below 300 $\mu$ m.
- 15 16. A process in which pellets are made from mineral particulate ore having substantially all particles below 250 $\mu$ m by adding binder in the presence of 5 to 15% by weight water (based on total mix) to form a substantially homogeneous moist mixture and pelletising the moist mixture, and in which the binder comprises about 0.002% to about 0.5% by weight, based on total mix, of a water soluble polymer that is added in the form of dry, free flowing, beads that are substantially all above 20 $\mu$ m, and below 300 $\mu$ m and that are made by reverse phase bead polymerisation from water soluble ethylenically unsaturated monomer or monomer blend.
- 20 17. A process according to claim 16 in which the polymer of the beads is nonionic, cationic or anionic having IV below 3 or above 16dL/g.

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## EUROPEAN SEARCH REPORT

Application Number

EP 88 30 2455

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
Y	EP-A-0 195 550 (ALLIED COLLOIDS LTD) * Claims; page 7, lines 18-19 *	1-17	C 22 B 1/244
Y	---		
Y	EP-A-0 053 921 (REVERTEX) * Claims *	1-17	
Y	---		
X,D	EP-A-0 203 855 (UNION CARBIDE CORP.) * Claims *	1-17	
X,D	---		
X	GB-A-2 000 787 (REVERTEX) * Claims *	1	
X	---		
X	GB-A-2 006 179 (REVERTEX) * Claims *	1	
X	---		
X	SOVIET INVENTIONS ILLUSTRATED, week J47, 12th January 1983, abstract no. 01893, Derwent Publications Ltd, London, GB; & SU-A-899 690 (BELOGOROD MEKHANOBR) 23-01-1982 * Abstract *	1	
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A	US-A-3 925 060 (R.A. BLOOM) * Column 2, line 66 *	1	TECHNICAL FIELDS SEARCHED (Int. Cl. 4)
A	---		
A	US-A-3 823 009 (G. LAILACH)		C 22 B
A	---		
A	US-A-3 180 723 (T.E. McCUALEY)		
A,D	US-A-3 893 847 (A.P. DERRICK)		
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A	AU-B- 445 417 (CATOLEUM PTY. LTD)		
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A	US-A-3 860 414 (W.J. LANG)		
A	---		
The present search report has been drawn up for all claims			
Place of search	Date of completion of the search	Examiner	
THE HAGUE	08-08-1988	JACOBS J.J.E.G.	
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone	T : theory or principle underlying the invention		
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